:5/22

DART AEROSPACE LTD	Work Order:	23190
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	4
		Page 1 of 2

			<u> </u>	rage 1012	<u> </u>
Step	Location	Procedure	Ву	Date	Qty
. 1	DC	Issue Travelers for: Batch	H	05.07.6	
2	MV .	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Identify for D3204-3 Batch: M17037	1 _	03.07.07	10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) Identify for D3204-5 Batch: M731		0807.07	
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) Identify for D3204-11 Batch: 11097		05.01.07	
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) Identify for D3204-9 Batch: M 5 /8		6307.07	10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 Identify as D3204-3		03.01.07	
7	QC2	Inspect parts as they come off the CNC machine		05.07.07	##_
8	MV	Deburr		33,01.01	l
9	QC8	Second check		0507.08	
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 Identify as D3204-5	î l	05.01.08	
11	QC2	Inspect parts as they come off the CNC machine	1 :	05 07.08	
12	MV	Deburr		os 01. 08	
13	QC8	Second check	, ,	80.7020	
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 Identify as D3204-11		6501.08	10
15	QC2	Inspect parts as they come off the CNC machine	i . I		10
16		Deburr	-	0501,08	10
17		Second check	a	0507B	10
18		Machine D3204-9 as per Folio FA357 and Dwg D3204 Identify as D3204-9	B6	05.07.09	10
19	QC2	Inspect parts as they come off the CNC machine		05.07.09	10

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DART AEROSPACE LTD	Work Order:	23190
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	4
2.13.		Page 2 of 2

Step	Location	Procedure	Ву	Date	Qty	
20	·MV	Deburr	B	05.07.89	10	
21	QC8	Second check	So	051-719	10	*
22	WA	Cut (2) D3204-13 per Assembly Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify as D3204-13 Batch: M17695	CPL	05 -07-14	10	
23	WA	Grind hypotenuse side	CPC	05.07.14	10	
24	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 Pick: Oty Part Number Description 1 D3204-1 Tube Description 1 D3204-1 Tube 1 D3204-1 Tube 1 D3204-041		05.07.1¥	10	87
25	QC5/9	Inspect weld	M	05/01/14	10	
26	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.14	10	
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 Note: Cover holes for bushing	FC	050714	10	
28	QC3	Inspect Powder Coat	SO	0/07/10	76	
29	GA	Install D3204-7 bushing as shown in Dwg D3204 Pick: Oty Part Number Description D3204-7 Bushing	TB SO	06-03-15	3	
30	QC5	Inspect work to Step 29		08-31/5	93	PF
31	ST	Identify and Stock	OL De	06/03/15	-3	
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part 172.62/172.62	A.	04/03/15	3	
-33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 Travelers: D3204-041 D3204-1 D3204-7		05/07/27	3	

Rev	Date	Change	Revised By	Approved
Α	04.04.14	1101110000	KJ/RF	
В	04.06.09	Added Travelers	KJ/RF R	#

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DART AEROSPACE LTD	Work Order:	23190	
Description: Arm	Part Number:	D3204-3	
Inspection Dwg: D3204 Rev: A		Page 1 of 1	

X First Article Prototype

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
6.00	+/-0.030					N
5.25	+/-0.030					
0.776	+/-0.010	_				
Ø0.760	+0.005/-0.000					
0.080	+/-0.010					
R0.50	+/-0.010					
2.373	+/-0.010	1		,		
0.750	+/-0.010					
R0.380	+/-0.010					
Ø0.375	+0.001/-0.000					
0.300	+/-0.010			<		
			0	>		
	January.	in e				
		\sim $^{\prime}$				<u>.</u>
			(0	W		
			7			
		02	20			
	12	ムノ				
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V	Nl					
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Measured by: 5 D	Audited by:	6	Prototype Approval:	N/A
Date: 03.07	Ot Date:	05.07.08	Date:	N/A

Rev	Date	Change		Revised by	Approved
_ A_	05.02.17	New Issue	(P/O D3204-041)	KJ/JLM (Approved
	5	i.		TIGOGETAL	



DART AEROSPACE LTD	Work Order:	23190
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204 Rev: A		Page 1 of 1

X First Article	Prototype
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Toloranco	Actual	Accept	Reject	Method of	Comments
lolerance	Dimension	Accept	Rojoot	Inspection	
+/-0.010					
+/-0.010					
+/-0.030					
+/-0.010					
+0.005/-0.000					
+/-0.010					
+/-0.005	-				
+0.005/-0.000					
+/-0.010					
+/-0.030					
+/-0.010					
,		_			
		>			÷
	. 0				
0	W		\		
		10	7		
	2	50	1		
	7 >	<u> </u>			
110	0				
1010					
					-
	+/-0.010 +/-0.030 +/-0.010 +0.005/-0.000 +/-0.010 +/-0.005 +0.005/-0.000 +/-0.010 +/-0.010	Tolerance Dimension +/-0.010 +/-0.030 +/-0.010 +0.005/-0.000 +/-0.010 +/-0.005 +0.005/-0.000 +/-0.010 +/-0.010 -/-0.010 -/-0.010	Tolerance Dimension Accept +/-0.010 +/-0.030 +/-0.010 +0.005/-0.000 +/-0.010 +/-0.005 +0.005/-0.000 +/-0.010 +/-0.010 -/-0.010 -/-0.010	Tolerance 1/-0.010	Tolerance Dimension Accept Reject Inspection +/-0.010 +/-0.030 +/-0.010 +0.005/-0.000 +/-0.015 +0.005/-0.000 +/-0.010 +/-0.010 -/-0.010 -/-0.010

	Measured by: $\leq N$	Audited by:	Prototype Approval:	N/A
Date: 65.01.08 Date: 05.07.08	Date: 65.01.08	Date: 05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue (P/O D3204-041)	KJ/JLM (



DART AEROSPACE LTD	Work Order:	23190
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204 Rev: A		Page 1 of 1

Prototype

X First Article

Talaranas	Actual	Accent	Reject	Method of	Comments
Tolerance	Dimension	Accept	Reject	Inspection	
+/-0.030					, eq. ()
+/-0.010					
+/-0.010					
+/-0.010					
+/-0.010					
+/-0.010					
+/-0.030		1			
+0.010/-0.000					
+/-0.010	^{				
+/-0.010	CANIC				
+0.005/-0.000	71.1				
	V	111			
	1	6			
	7,2				-
	+/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +0.010/-0.000 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +0.010/-0.000 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension Accept +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension Accept Reject +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension Accept Reject Inspection +/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +/-0.030 +0.010/-0.000 +/-0.010 +/-0.010 +/-0.010

				T:
Measured by:	181.	Audited by:	Prototype Approval	N/A
Date:	05.07.09	Date:	Date	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	S/11/

DART AEROSPACE LTD	Work Order:	23190
Description: Plate	Part Number:	D3204-11
Inspection Dwg: D3204 Rev: A		Page 1 of 1

X	First Article	Pro	ototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010					3.21
0.598	+/-0.005	and the second s				
Ø0.191	+0.005/-0.000					
0.700	+/-0.010					
R0.250	+/-0.010					
0.848	+/-0.010					
R0.377	+/-0.010					,
			C			
		0	2	>		
		me				
	< 0					·
				J		
		_		$\mathcal{L} \cup \mathcal{L}$		*
		2)		
	10	L -	7			
			١			
	V					

Measured by: $\leq \mathcal{D}$	Audited by:	Prototype Approval:	N/A
Date: 05.01.08	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
^	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	X /M/
A	03.02.17	14CM 102GC 7		<i>F. 1</i>

DART AEROSPACE LTD	Work Order:	23190
Description: Bushing	Part Number:	D3204-7
Dwg: D3204 Rev. A page 2	Qtv:	4
Ref:	3.3.	Page 1 of 1

Step	Location	Procedure \	Ву	Date	Qty
1	DC	Issue Traveler	7	-1 -1 -	
		Dwg not required	AC	05/05/09	4
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" (M303R0.500) Identify for D3204-7 Batch:		0	
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-7			
4	МС	Deburr	(4
5	QC8	Second check		11/1	7
6	МС	Go to D3204-041 for assembly			

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
В	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF	₹F

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PF 34.36.21



DART AEROSPACE LTD	Work Order:	<i>23190</i>
Description: Tube	Part Number:	D3204-1
Dwg: D3204 Rev. A page 2	Qty:	4
Ref:		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	10	05/05/09	4
		Dwg not required	1246	03/05/09	7
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204	ļ		ĺ
		Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall			
	7	(M6061T6T0.750W.125) Identify for D3204-1 Batch: M15979	T =	-5/06/06	4
			. ت.ر	3770000	القيد
3	QC2	Inspect parts as they come off the CNC machine	ير با	05/06/06	5
	·	Identify as D3204-1			1
4	MC	Deburr	KG-	5/66/06	5
			1	7706700	
5	QC8	Second check	R	40.20	<
					<u>ر</u>
6	МС	Go to D3204-041 for welding	FAC	05.07.12	5
			UPL	05.07.16	

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B		Change Step 6; remove Steps 7 & 8	KJ/RF A	\$F

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PF 04.06.21

DART AEROSPACE LTD	Work Order:	
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204 Rev: A		Page 1 of 1

X	First Article	Prototype

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension		Differsion	1		κ.	
Ø0.750	+/-0.010	0.756	V			
Ø0.500	+/-0.010	0.509	1			
6.110	+/-0.010	0.7509	V			
	•					
					-	
					·	
		9				
			-			
			,			

	Audited by:	P	Prototype Approval:	N/A
Measured by:). 5			Date:	N/A
Date: 05/06/06	Date:	05.06.0		

			Revised by	Approved
Rev	Date	Change (DIO DOOM 4)	KJ/JLM (11/1
Α	05.02.17	New Issue (P/O D3204- 1-)		25 C24 XXV
<u> </u>			幽 野胃 作 施力	1. 1.